



Dart Aerospace Ltd.  
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**D5149-1TRN**  
**Job Sheet 181582**



**Part No:** D5149-1TRN

**Job Qty:** 2 ea

**Part Name:** Fwd Step Base Turning Detail



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 8/1/18

**Job Tracking No:**

**Due Date:** 8/10/18

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG REV D SHEET 9 IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

**Ship Via:**

**Bill of Materials**

**Job Routing**

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 2 Ea  | 8/10/18    | 8/10/18  | 0.00      | 0.00    | Start Up Machining-3  |           |          |
| 100   | Doosan             | 2 pcs | 8/10/18    | 8/10/18  | 0.56      | 1.31    | Doosan                |           |          |
| 110   | QC                 | 2 pcs | 8/10/18    | 8/10/18  | 0.00      | 0.00    | QC2 Machining-3       |           |          |
| 120   | QC                 | 2 pcs | 8/10/18    | 8/10/18  | 0.00      | 0.00    | QC8 Machining-3       |           |          |
| 130   | Packaging          | 2 pcs | 8/10/18    | 8/10/18  | 0.00      | 0.00    | Packaging3-2          |           |          |
| 140   | QC21-SA            | 2 Ea  | 8/10/18    | 8/10/18  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - Turn blank as per Folio FB355  
Descriptions: 130 - LOCATION: MAT060

21  
9-89

*Handwritten signatures and dates:*  
ML 18/09/18  
ML 18/09/18  
SEP 17 2018

**Job BOM**

| Part / Item   | Component Name           | Quantity           | Operation             | Container |
|---------------|--------------------------|--------------------|-----------------------|-----------|
| M6061T6R3.000 | 6061-T6 Round Bar 3.000" | .8320 ft (.416 ea) | 90-Start up Operation | 5076995   |

**Job Allocations**

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6R3.000  | 1        | 14        | 0         |

| Part Specifications |               |                                |                |        |                  |
|---------------------|---------------|--------------------------------|----------------|--------|------------------|
| Spec No             | Description   | Target/Tolerance               | Limits         | Type   | Special Comments |
| 1                   | Fwd Step Base | 2.824Inches + 0.012<br>- 0.001 | 2.836<br>2.823 |        |                  |
| 2                   | Fwd Step Base | 2.453Inches + 0.012<br>- 0.001 | 2.465<br>2.452 |        |                  |
| 3                   | Fwd Step Base | 0.032Inches ± 0.010            | 0.042<br>0.022 | Radius |                  |
| 4                   | Fwd Step Base | 0.060Inches ± 0.010            | 0.070<br>0.050 |        |                  |
| 5                   | Fwd Step Base | 0.060Inches ± 0.030            | 0.090<br>0.030 |        |                  |
| 6                   | Fwd Step Base | 0.875Inches ± 0.010            | 0.885<br>0.865 |        |                  |
| 7                   | Fwd Step Base | 3.190Inches ± 0.030            | 3.220<br>3.160 |        |                  |
| 8                   | Fwd Step Base | 4.000Inches ± 0.030            | 4.030<br>3.970 |        |                  |

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**Container No: S109432**



**Part: D5149-1TRN**

**Job No: 181582**

**Serial No/Batch: S109432**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:**

Date: 09/12/18